

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006183**Date Inspected:** 02-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the paint shop)

Segment 4BE

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the access hole side plate stiffeners. The Weld Designations are as follows:

SSD17-PP27-179, 180, 183 and 184

During random verification Ultrasonic testing (UT) of the access hole side plate stiffeners weld# SSD17-PP27-179, Caltrans Quality Assurance (QA) Inspector discovered one (1) rejectable indication previously overlooked by ZPMC Quality Control (UT) Technicians.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as corner assembly component welds. The Weld Designations are as follows:

SSD18-PP28-144, 145, 146, 147, 148, 149, 150 and 154.

CSD4-PP28-073, 074, 134, 068, 071, 072, 132, 133, 069, 070, 130, 131, 087, 088, 143 and 144.

CSD2-PP28.5-049, 050, 051, 052, 053, 054, 055, 056, 059, and 060.

SSD23-PP28.5-129, 130, 133, 134, 131, 132, 135, 136, 161 and 162.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

CA012-025, 026, 027, 028, 037, 038, 039, 040, 061, 062, 063, 064, 073, 074, 075, 076, 085, 086, 087 and 088.
SEG20D-007, 008, 011, 012, 013, 014, 030, 031, 034, 035, 036 and 037.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as longitudinal truss bracket welds. The Weld Designations are as follows:

SEG20F-001, 004, 005, and 008.

SEG20G-001

Segment 1BE

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as Floor beam to bottom plate welds. The Weld Designations are as follows:

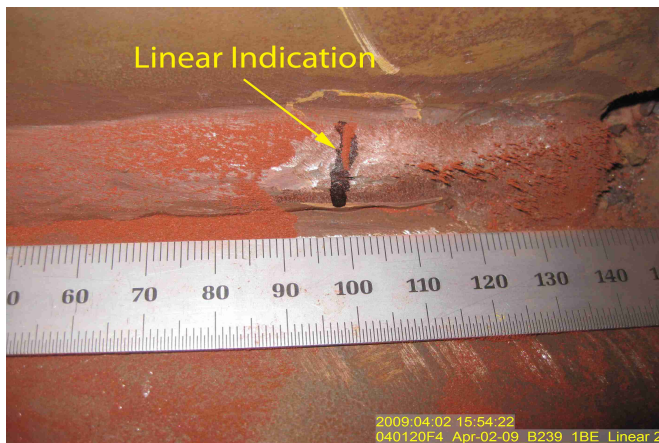
SSD49-PP12-106~129

SSD49A-PP12-106~123

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer
